

Work Order ID 135486

Friday, December 18, 2015 12:14:32 PM

135486

Reprint

Page 1

Item ID: D412-704-015

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 8/5/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/12/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: DEC 18 2015

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-704	D								
100	Document Control	0.00			DAS				
100	DOCUMENT CONTROL				27				
DC	Memo	0.00			9-89				
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-704-015 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DEC 21 2015

DAS
28
9-89

DEC 18 2015

DAS
28
9-89

DAS
27
9-89

DEC 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-704-

015 Location: _____

PPP Rev: _____

F9018

DAS

27

9-29

DEC 24 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS

DEC 24 2015

MCS

DEC 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Friday, December 18, 2015 12:14:40 PM

Page 1

Work Order ID: 135486

135486

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 8/5/2015

Required Date: 8/12/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC IPP
REV:B 12.04.20 per cen-566 DD verf:EC IPP REV:C
12.05.10 per ECN 12-583 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-704-141 *D412-704-141* Pedal Assembly		Manufactured	No			110	Each	2.0000	1	1			
									**				DAS 28 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST229B				2					
				119629				1					
				136672				1					
D412-704-045 *D412-704-045* Cable Ass'y		Manufactured	No			110	Each	4.0000	1	1			
									**				DAS 28 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST215				4					
				136528				2					
				136529				2					
D3207-5 *D3207-5* Bracket		Manufactured	No			110	Each	20.0000	1	1			
									**				DAS 28 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST024				20					
				116991				20					
D3207-7 *D3207-7* Packer		Manufactured	No			110	Each	19.0000	1	1			
									**				DAS 28 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST024				19					
				110077				19					

DEC-21-2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Misidentified ☐	Past Due ☐								

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Page 2

Work Order ID: 135486

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Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 8/5/2015

Required Date: 8/12/2015

Start Qty: 1.00

Required Qty: 1.00

D3207-9 Manufactured No

110 Each 11.0000 1 1

D3207-9

Bracket

**

DAS
6 28
9-89

Location Loc Qty Loc Code

ST024 11

122604 11

D3208-1 Manufactured No

110 Each 8.0000 1 1

D3208-1

Doubler

**

DAS
6 28
9-89

Location Loc Qty Loc Code

ST025 8

124260 8

D3208-11 Manufactured No

110 Each 5.0000 1 1

D3208-11

Filler

**

DAS
6 28
9-89

Location Loc Qty Loc Code

ST026 5

122473 5

D3208-3 Manufactured No

110 Each 13.0000 1 1

D3208-3

Pedal Mount Angle

**

DAS
6 28
9-89

Location Loc Qty Loc Code

ST025 13

117181 13

D3208-7 Manufactured No

110 Each 14.0000 1 1

D3208-7

Filler

**

DAS
6 28
9-89

Location Loc Qty Loc Code

ST025 14

119559 14

DAS
27
9-89

DEC 21 2015

Friday, December 18, 2015 12:14:40 PM

Shop Packet Print

Page 2

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Start Date: 8/5/2015

Required Date: 8/12/2015

Start Qty: 1.00

Required Qty: 1.00

D3208-9 Manufactured No 110 Each 5.0000 1 1

D3208-9

Doubler

DAS 6 28 9-89

DAS 27 9-89

Location Loc Qty Loc Code

ST025 5

126281 5

D3214-1 Manufactured No 110 Each 7.0000 1 1

D3214-1

Decal

DAS 6 28 9-89

DAS 27 9-89

Location Loc Qty Loc Code

ST026 7

131887 7

D4610-1 Manufactured No 110 Each 14.0000 1 1

D4610-1

Doubler

DAS 6 28 9-89

DAS 27 9-89

Location Loc Qty Loc Code

ST112 14

119696 14

D4610-3 Manufactured No 110 Each 3.0000 1 1

D4610-3

Doubler

DAS 6 28 9-89

DAS 27 9-89

Location Loc Qty Loc Code

ST112 3

98863 3

D4610-7 Manufactured No 110 Each 3.0000 1 1

D4610-7

Cover

DAS 6 28 9-89

DAS 27

Location Loc Qty Loc Code

ST117 3

131891 3

Friday, December 18, 2015 12:14:40 PM

Shop Packet Print

DEC 21 7 15

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Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

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Friday, December 18, 2015 12:14:40 PM

Page 4

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Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 8/5/2015

Required Date: 8/12/2015

Start Qty: 1.00

Required Qty: 1.00

MS21919-DG5

Purchased

No

110

Each

18.0000

4

4

MS21919-DG5

Clamp

**

16984

68-6
0
28
9-89

BAS

27

9-89

D4622-1

Manufactured

No

110

Each

10.0000

1

1

D4622-1

Placard

**

68-6
6
28
9-89

Location

Loc Qty

Loc Code

ST297

18

m129499

18

Location

Loc Qty

Loc Code

st113

10

132587

10

D4622-3

Manufactured

No

110

Each

12.0000

1

1

D4622-3

Placard

**

DAS
6
28
9-89

Location

Loc Qty

Loc Code

st113

12

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MS35489-149

Purchased

No

110

Each

92.0000

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MS35489-149

GROMMET

**

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Location

Loc Qty

Loc Code

ST274

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPLOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPLOT'S EMERGENCY CARGO RELEASE KIT (205)
		X					D412-704-015	COPLOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		1		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
1		1					D3207-5	BRACKET
1	1	1					D3207-7	PACKER
		1					D3207-9	BRACKET
1							D3207-11	BRACKET
1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1	1	1					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	1					D3208-7	FILLER (OR ECM 999709-3)
1		1					D3208-9	DOUBLER
1		1					D3208-11	FILLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
		1					D4610-7	COVER
				1			D4611-1	BUSHING
		1					D4622-1	PLACARD
		1					D4622-3	PLACARD
			1	1	1	1	AN3-10A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT
				1			MS20002-4	WASHER

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Date: 14.12.02

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IIN-D412-704
Page 22 of 22

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
				1			MS20004-24	BOLT
			3	3	2	2	MS21042L3	NUT (OR MS21042-3)
			5	5			MS21042L4	NUT (OR MS21042-4)
4	4	4					MS21919DG5	CLAMP
			1				MS24694-S102	SCREW
				1			MS24694-S104	SCREW
	2						MS35489-10	GROMMET
		1					MS35489-149	GROMMET
			1	1			MS9519-10	BOLT
			4	4	2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
			5	5	2	2	NAS1149D0363J	WASHER (OR AN960JD10)
			3	2			NAS1149D0416J	WASHER (OR AN960JD416L)
			14	13			NAS1149D0463J	WASHER (OR AN960JD416)
					3	3	NAS509-3	NUT

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